



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-041
Job Sheet 170923



Part No: D3296-041

Job Qty: 4 ea

Part Name: Replacement Interior Door For -111



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 2/9/18

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Revised Steps 06-11-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/8/18	2/8/18	0.00	0.00	Start Up Small Fab-2		FEB 15 2018
100	Small Fab	4 pcs	2/8/18	2/8/18	0.00	1.61	Small Fab-3		
110	QC	4 pcs	2/8/18	2/8/18	0.00	0.00	QC5		
120	Powdercoat	4 pcs	2/8/18	2/8/18	0.00	0.31	Powdercoat4		
130	QC	4 pcs	2/8/18	2/8/18	0.00	0.00	QC3		
140	Small Fab	4 pcs	2/9/18	2/9/18	0.00	1.61	Small Fab-3		
150	QC	4 pcs	2/9/18	2/9/18	0.00	0.00	QC5		
160	Packaging	4 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-1		
170	QC21-SA	4 Ea	2/9/18	2/9/18	0.00	0.00	QC21		

M/138700. START: 2:45. OVT: 3:20 FINISH: 3:15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3161-7	Hinge 14.0"	4 Ea (1 ea)	90-Start up Operation	
D3161-9	Hinge 17.0"	4 Ea (1 ea)	90-Start up Operation	
D3296-1	Door Panel	4 Ea (1 ea)	90-Start up Operation	
D3296-3	Door Panel	4 Ea (1 ea)	90-Start up Operation	
MS20470AD4-6	Rivet, Universal Head	4 Ea (1 ea)	90-Start up Operation	
D2137	Decal(No Step)	4 Ea (1 ea)	140-Small Fab	
D2419	Handle	4 Ea (1 ea)	140-Small Fab	
D2462	Neoprene Seal (\$Per Foot)	11.2664 ft (2.8166 ea)	140-Small Fab	
D2728-1	Dart Logo Label Small	4 Ea (1 ea)	140-Small Fab	
MS20470AD4-4	Rivet, Universal Head	100 Ea (25 ea)	140-Small Fab	
NAS1149DN632J	Washer	4 pcs (1 ea)	140-Small Fab	

5023230
F160690
F115832
5027554
5024482

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3161-7	4	4	0
	D3161-9	4	4	0
	D3296-1	4	1	0
	D3296-3	4	0	0
	MS20470AD4-6	4	884	0
140-Small Fab	D2137	4	18	0
	D2419	4	9	0
	D2462	11	254	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐				Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		QTY Effective : _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S042807 Part: D3296-041 Serial No/Batch: S042807 Revision: D3296 Inspector: Date: 02/15/18 15:05 PM			
Description Work Order Deviation				MRB (QSI042) Approval					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

Part Specifications				
D2728-1	4	0	0	0
MS20470AD4-4	100	4,187	0	0
NAS1149DN632J	4	491	0	0
Specifications could not be found.				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

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BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																														
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																														
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																														
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																														
Countersink ☐	Off-set ☐	Drawing ☐																																																																														
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																														
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																														
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																														



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000933

Tel (613) 632-5200

Containers on Master Unit 000933				
Serial No	Part No	Customer Part No	Status	Quantity
F160691	D3161-7		Allocated	4
F164437	D3161-9		Allocated	4
S040485	D3296-1		Allocated	4
S040492	D3296-3		Allocated	4

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